



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5560-1

Job Sheet 183508



Part No: D5560-1

Job Qty: 14 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/19/18

Job Tracking No:

Due Date: 10/10/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: Dwg D5560-1 Rev.B IPP REV. A NEW ISSUE 17/10/17 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	14 Ea	10/10/18	10/10/18	0.00	0.00	Start Up Waterjet		DL 18/09/24
120	Waterjet	14 pcs	10/10/18	10/10/18	0.00	4.75	Waterjet 2 OMAX		DL 18/09/24
130	CNC Vertical Machining	14 pcs	10/10/18	10/10/18	0.66	22.95	HAAS1-1		DTP 18/10/16
140	QC	14 pcs	10/10/18	10/10/18	0.00	0.00	QC2 Machining-4	J.C. 18/10/18	
150	QC	14 pcs	10/10/18	10/10/18	0.00	0.00	QC8 Machining-4		5.0 18-10-21
151	Packaging	14 pcs	10/10/18	10/10/18	0.00	0.00	Packaging3	5/11/18	NOV 01 2018
190	QC21-SA	14 Ea	10/10/18	10/10/18	0.00	0.00	QC21	21	NOV 05 2018

Part Op 120 - Cut Blank as per File D5560-1_BLANK

Descriptions: 130 - Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FB624 and Dwg D5560 3-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	46.7600 sf (3.34 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	47	917	0

Part Specifications

Specifications could not be found.



Container No: S112879



Part: D5560-1

Job No: 183508

Serial No/Batch: S112879

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/24/18

Plex 9/19/18 9:41 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 183508
Description: Bear paw		Part Number: 5560-1
Inspection Dwg: 5560 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06x45°	(±).03	0.06x45°	✓		Ver	
4.250	(±).01					
0.930	(±).01	0.930	✓		Ver	
0.300	(±).015	0.305	✓		D.G.	
0.750	(±).01	0.750	✓		Ver	
0.250	(±).02	0.250	✓		D.G.	
Ø 0.266	+0.005 -0.001	0.266	✓		Ver	
0.38	+0.03 -0.00	0.395	✓		Ver	
R.0.25	(±).03	0.25	✓		R.G.	
0.25	+0.03 -0.00	0.265	✓		Ver	
0.95	(±).03	0.955	✓		Ver	
0.63	(±).03	0.630	✓		Ver	
0.75	(±).03	0.750	✓		Ver	
0.30x45°	(±).03x(±).5°	0.30x45°	✓		Ver	
0.38	(±).03	0.38	✓		Ver	
1.75	+0.00 -0.03	1.74	✓		Ver	
3.000	(±).01	3.000	✓		Ver	
9.000	(±).01	9.000	✓		TAPE	
5.500	(±).01	5.500	✓		Ver	
19.00	(±).03	19.00	✓		TAPE	
20.35	(±).03	20.35	✓		TAPE	
0.38	(±).03	0.38	✓		Ver	
1.75	(±).03	1.76	✓		Ver	
2.05	(±).03	2.05	✓		Ver.	
R.0.50	(±).03	R.0.50	✓		R.G.	
11.75	(±).03	11.75	✓		TAPE	

Measured by: DAS 52	Checked by: B.a	QC Inspector:
Date: 18/10/15	Date: 18-10-21	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

